

**Work Order ID 81049****\*81049\***

Page 1

March-07-12 2:22:28 PM

Item ID: D206-559-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bearpaw

Start Date: 07/03/2012 Start Qty: 10.00 **\*10\***

Cust Item ID:

Required Date: 21/03/2012 Req'd Qty: 10.00 **\*10\***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/03/07

Tooling:

Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

DSI 9527

rev A

IIN-D206-559

rev L

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPPD206-559-011 CHG007

160

0.00

**\*160\***

Pick Kit

Packaging

Memo

0.00

Packaging

*Handwritten notes:*  
✓ MLJ 12-5-1  
(5)  
✓ 4/2/5/07 (5) 82

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

**Work Order ID 81049****\*81049\***

Page 2

March-07-12 2:22:28 PM

Item ID: D206-559-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bearpaw

Start Date: 07/03/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 21/03/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170 QC4- 100% Inspect kits for completeness

0.00

**\*170\***

QC

Memo

0.00

Quality Control

180

0.00

**\*180\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD206-559-011  
Location: \_\_\_\_\_

190

0.00

**\*190\***

QC

Memo

0.00

Quality Control

QC21- Final Inspection - Work Order Release

5x \_\_\_\_\_ 12-05-01

12/5/11

12-05-01

**Dart Aerospace Ltd**

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March-07-12 2:22:35 PM

Page 1

Work Order ID: 81049

\*81049\*

Parent Item: D206-559-011

\*D206-559-011\*

Parent Item Name: Bearpaw

Start Date: 07/03/2012

Required Date: 21/03/2012

Start Qty: ~~10.00~~

Required Qty: 10.00

Comments: IPP Rev:C04.02.17Blank size changedKJ/JLM  
 IPP Rev:D 07-01-02 Was K10007 JLM  
 IPP Rev:E 08-05-05 up a chg DD verified by:EC  
 IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified  
 By:EC IPP Rev G 10.10.04 per DSI9527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-17A		Purchased	No			160	Each	470.0000	<del>8</del>	8040			
<div style="display: flex; justify-content: space-between;"> <span>S+ *AN4-17A*</span> <span>**</span> <span></span> </div>													

Location	Loc Qty	Loc Code
ST358	24	
112314	8	
116419	16	
116704	0	
ST359	446	
118983	300	
120187	146	

118983

AN4-20A		Purchased	No			160	Each	446.0000	<del>8</del>	8040			
<div style="display: flex; justify-content: space-between;"> <span>S+ *AN4-20A*</span> <span>**</span> <span></span> </div>													

Location	Loc Qty	Loc Code
GA	50	
116419	50	
ST359	396	
117514	96	
118983	100	
119127	200	

119127

1/3/5/01 (8)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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March-07-12 2:22:35 PM

Page 2

Work Order ID: 81049

\*81049\*

Parent Item: D206-559-011

\*D206-559-011\*

Parent Item Name: Bearpaw

Start Date: 07/03/2012

Required Date: 21/03/2012

Start Qty: 10.00

Required Qty: 10.00

AN960JD416

NAS1149D0463J

Purchased

No

160

Each

20.0000

16

160 80

\*\*

12/2008

\*AN960JD416\*

Washer

Location

Loc Qty

Loc Code

ST351

20

116289

20

D2182B

Manufactured

No

160

f

403.3942

1.666

16.66 8.33

\*\*

8/33

\*D2182B\*

Rubber Cushion

Location

Loc Qty

Loc Code

ST410

403.39417

63413

1.6

66063

41.61817

73932

360.176

73932

(D2182B050) Cut (4) at 5.00" as per dwg \*\*\*per kit\*\*\*

D2274

Manufactured

No

160

Each

147.0000

8

80 40

\*\*

78233

200

\*D2274\*

Radius Block

Location

Loc Qty

Loc Code

ST007

147

72121

32

78589

115

D2435

Manufactured

No

160

Each

0.0000

2

20 10

\*\*

81062

200

\*D2435\*

Bearpaw, 206

March-07-12 2:22:35 PM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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March-07-12 2:22:35 PM

Page 3

Work Order ID: 81049

\*81049\*

Parent Item: D206-559-011

\*D206-559-011\*

Parent Item Name: Bearpaw

Start Date: 07/03/2012

Required Date: 21/03/2012

Start Qty: 10.00

Required Qty: 10.00

D2438

Manufactured No

160 Each

86.0000

\*D2438\*

Clamp

\*\*

## Location

## Loc Qty

## Loc Code

ST456

86

77038

8

78594

78

Manufactured No

160 Each

417.0000

D2529

\*D2529\*

Washer

\*\*

## Location

## Loc Qty

## Loc Code

ST010

417

66953

2

79221

275

79485

140

Purchased No

160 Each

4,298.000

MS21042L4

\*MS21042L4\*

Nut

\*\*

## Location

## Loc Qty

## Loc Code

ST300

4298

117441

51

117601

157

118451

133

119017

200

119075

3757

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

March-07-12 2:22:35 PM

Page 4

Work Order ID: 81049

\*81049\*

Parent Item: D206-559-011

\*D206-559-011\*

Parent Item Name: Bearpaw

Start Date: 07/03/2012

Required Date: 21/03/2012

Start Qty: 10.00

Required Qty: 10.00

QS200-M44S

Purchased

No

160

Each

34.0000

20/0

\*\*

\*QS200-M44S\*

Clamp

Location

Loc Qty

Loc Code

ST455

34

115410

2

115589

3

117460

13

119436

16

117460

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D206-559 REV. K OR EARLIER AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-559 REV. 2 OR EARLIER  
REF. TCCA STC: SH92-17  
REF. FAA STC: SH1031NE

## PURPOSE:

For D206-559-011/-013/-021/-023/-031/-033 bearpaw kits, the AN4 bolts specified were for installation with the aft skidtube wearshoe removed. Bolt lengths are increased to accommodate installation with the skidtube wearshoe installed, which is more practical.

## CHANGE:

The parts list is updated as shown on sheet 2 of this service instruction, for bearpaw kits: D206-559-011 at CHG 007, D206-669-013 at CHG 006, D206-559-021 at CHG 008, D206-559-023 at CHG 007, D206-559-031 at CHG 002, and D206-559-033 at CHG 002.

SHOP COPY

Figure 4 of D206-559 and Figure 32-3 of ICA-D206-559 are amended as follows:

UNCONTROLLED COPY

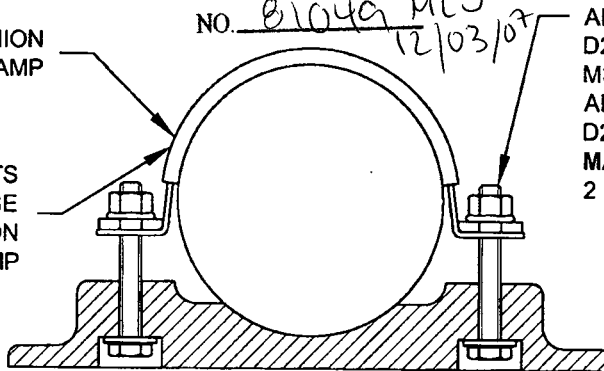
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 81049 MLJ  
12/03/07

D2182B050 CUSHION  
D2438 CLAMP  
  
FOR D206-559-013/-023 KITS  
ON TAPERED SKIDTUBES USE  
D2732-050 RUBBER CUSHION  
D2438 CLAMP



AN4-17A OR AN4-20A BOLT\*\*  
D2529 WASHER  
MS21042L4 NUT  
AN960JD416 WASHER\*\*  
D2274 RADIUS BLOCK  
MAX TORQUE 20 IN-LB  
2 PL PER CLAMP

\*\*USE AN4-17A BOLTS WITH AN AN960JD416 (OR NAS1149D0463J) WASHER IF INSTALLING BEARPAW ON 3.0" DIA. TUBE OR SMALLER. USE AN4-20A BOLTS WITH TWO AN960JD416 WASHERS IF INSTALLING BEARPAW ON TUBE LARGER THAN 3.0" DIAMETER (DART TUBE). ADDITIONAL AN960JD416 WASHERS MAY BE ADDED UNDER NUT TO ENSURE 2-4 THREADS IN SAFETY. IT IS ALSO ACCEPTABLE TO USE LONGER/SHORTER AN4 BOLTS IF REQUIRED TO ENSURE BEARPAW IS HELD SECURELY.

FIGURE 4: TYPICAL CLAMPING DETAIL (D206-559)  
FIGURE 32-3: TYPICAL CLAMPING DETAIL (ICA-D206-559)

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY: [Signature]  
D. SHEPHERD (DE # 02)

DATE: 10.06.30  
CERT. NO.: SH92-17  
ISSUE NO.: 7

A	NEW ISSUE	CP	10.06.30
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>[Signature]</u>	DART AEROSPACE LTD	
DRAWN	<u>[Signature]</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>[Signature]</u>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9527	SHEET 1 OF 2
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	BOLT CHANGE	NTS
DATE	10.06.30	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries  
H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

5.0 PARTS LIST (D206-559 REV. K)  
32.7 PARTS LIST (ICA-D205-559 REV. 2)

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			20	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						2	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						2	D4010-041	BEARPAW ASSEMBLY
						8	D4011-1	CLAMP, SHORT
						2	D4011-3	CLAMP, LONG
						8	D4011-5	CLAMP, SHORT (OEM)
						10	D4012-1	CUSHION
						2	AN4C10A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT (WAS AN4-15A)
						4	AN4C13A	BOLT
						8	AN4C15A	BOLT
						8	AN4C17A	BOLT
16	24	16	24				AN960JD416	WASHER (OR NAS1149D0463J)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						20	MS21043-4	NUT
				8	12		NAS1149D0463J	WASHER (OR AN960JD416)
2		2					QS200M44S	CLAMP






81049

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY:   
D. SHEPHERD (DE # 02)

DATE: 10.06.30  
CERT. NO.: SH92-17  
ISSUE NO.: 7

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9527 SHEET 2 OF 2
APPROVED		TITLE SCALE
DE APPR.		BOLT CHANGE NTS
DATE	10.06.30	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>

Dart Aerospace Ltd

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NOTE: Date & initial all entries



## 5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050,	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
12							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP